

Work Order ID 48152

Friday, June 26, 2009 9:18:37 AM



Page 1

Item ID: D350-600-242

Accept



Setup Start



Revision ID: C

Item Name: Spacepod, RH, AS350/355

Stop



Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 09/10/13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D350-600

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

Sc 10/12*

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes in D3188-2 using drill jig DT8971 2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188 3-Deburr 4-Install inserts in D3188-2 as per Dwg D3188.

FT 09-10-19

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

=> Sc 10/12

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Page 2

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Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

1-Cut D2986 Neoprene Foam per template D2986T1

Small Fab

NA as per B# 48237
BT 09-10-17

(PTO)

140

0.00



Small Fab

Small Fab

Memo

0.00

****This step separates hardware, previous steps is for body & floor****

Small Fab

150

0.00



Small Fab

Small Fab

Memo

0.00

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

☐

Hardware on previous steps is for door ass'y☐ 1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight. ☐ A/R Hysol batch: _____

Small Fab



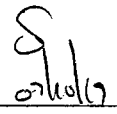


Hysol 956 B112167

★ SEE W/D CHG milled fibres m 100859
OVER

BT 09-10-17

W/O: 48152

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.10.14	150	Acceptable to substitute EA956 FOR EA934 FOR DRILLING THROUGH HOLES @ SECTION I-7 & J-5 OF DWG D3188. <i>Permanent change</i>				 09.10.14 PS/042	
09-10-19	130	Adhere D2986 neoprene foam to bottom side of D3187-2 spaced floor using contact adhesive B 112225		09-10-19 09/10/23	1		

Part No: D350-600-242 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 48152

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Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

alms

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Salisbury

180



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

0.00

*Wing w/c, S**MO 091101 19*

Work Order ID 48152

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Friday, June 26, 2009 9:18:37 AM

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Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

*BR 06-11-19**①*

QC

Memo

0.00

Quality Control

200

~~QC4- 100% Inspect kits for completeness~~

0.00

Pick kit 6*see holes -*
Quality Control

Memo

0.00

PTO

210

QC4- 100% Inspect kits for completeness

0.00

2801/01/20

QC

Memo

0.00

Quality Control

*①**4*

W/O: 48152

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-10-19	200	Perm. Change add to pick list MS21042208 x 14 AN960308 x 12	FT A	09-10-19 09/10/23			S 09/10/19

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 48152

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Item ID: D350-600-242

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Revision ID: C

Stop



Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

220



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D350-600-141 □ Location: _____ □ PPP Rev: _____

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/14/21 (1)

09/10/23

W 37-10-2B

Picklist Print

Friday, June 26, 2009 9:18:36 AM

Page 1

Work Order ID: 48152

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ ALS4-1032-130 		Purchased	No			110	Each	0.0000	28.0000			SL
Insert												
✓ D3186-4RevD 		Manufactured	No			110	Each	0.0000	1.0000			48152 B 01 RT 09-10-13
Spacepod Door, RH												
✓ D3187-2RevC 		Manufactured	No			110	Each	0.0000	1.0000			B31836 SP
Spacepod Floor												
✓ D3188-2MRevE 		Manufactured	No			110	Each	0.0000	1.0000			48152 A RT 09-10-13
SPACEPOD BODY RH												
✓ D3015-3RevB 		Manufactured	No			120	Each	0.0000	1.0000			48238 SP
Locknut												
✓ A3235-020-935 		Purchased	No			130	Each	0.0000	8.0000			M106150 SP
Washer - Countersunk												
✓ AN526C832R24 		Purchased	No			140	Each	0.0000	4.0000			M110179 SP
screw												
✓ AN960JD516 		Purchased	No			140	Each	0.0000	1.0000			M112794 SP
Washer												
✓ AN960JD8 		Purchased	No			140	Each	0.0000	4.0000			M111578 SP
Washer												

9/10/14

Picklist Print

Page 2

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Work Order ID: 48152

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355










Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2179RevB 		Manufactured	No			140	Each	0.0000	2.0000			
Doubler												
✓ D2237RevD1 		Manufactured	No			140	Each	0.0000	2.0000			
Striker Plate												
✓ D2986RevB 		Manufactured				140	sf	0.0000	5.9158			
Black Neoprene Foam .125												
✓ D3015-3RevB 		Manufactured	No			140	Each	0.0000	1.0000			
Locknut												
✓ D3538-1RevA 		Manufactured	No			140	Each	0.0000	2.0000			
Hinge Bracket												
✓ D3554-7RevA 		Manufactured	No			140	Each	0.0000	1.0000			
Ball Stud												
✓ D3567-2RevA 		Manufactured	No			140	Each	0.0000	1.0000			
Decal												
✓ MS20426AD4-5 		Purchased	No			140	Each	0.0000	4.0000			
Rivet												
✓ AN526C832R10 		Purchased	No			150	Each	0.0000	8.0000			
Screw												

B35432 SP

B50340 SP

48237 SP

37674 SP

B48197 SP

B37674 SP

B39678 SP

6733 SP

M104603 SP
9/10/14 SP

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Picklist Print

Page 3

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Work Order ID: 48152

Parent Item: D350-600-242RevC

Parent Item Name: Spacepod, RH, AS350/355



















Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN526C832R14 		Purchased	No			150	Each	0.0000	2.0000		M104916	30
Screw												
✓ AN960JD10 		Purchased	No			150	Each	0.0000	2.0000		M112369	50
Washer												
✓ AN960JD8 		Purchased	No			150	Each	0.0000	4.0000		M111578	50
Washer												
✓ D2228RevB 		Manufactured	No			150	Each	0.0000	4.0000		B30679	50
Bracket Plate												
✓ D2464RevB 		Manufactured	No			150	f	0.0000	11.3684		39669 B30679 ✓	50
3/4 Seal												
✓ D2585RevB 		Manufactured	No			150	Each	0.0000	2.0000		B350544	50
Mounting Channel												
✓ D2586RevD 		Manufactured	No			150	Each	0.0000	2.0000		B47183	50
Door Latch												
✓ D2621RevB 		Manufactured	No			150	Each	0.0000	2.0000		B46848	50
Latch Plate, 350 Spacepod												
✓ D2857-1RevB 		Manufactured	No			150	Each	0.0000	1.0000		B45888	50
Hinge Bracket												

9/10/14 50

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Picklist Print

Page 4

Friday, June 26, 2009 9:18:36 AM

Work Order ID: 48152



Parent Item: D350-600-242RevC



Parent Item Name: Spacepod, RH, AS350/355

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D2857-2RevB 		Manufactured	No			150	Each	0.0000	1.0000		B43363	SP
Hinge Bracket												
✓ D3557-1RevA 		Manufactured	No			150	Each	0.0000	1.0000		B46887	SD
Bracket												
✓ D3567-2RevA 		Manufactured	No			150	Each	0.0000	1.0000		B39678	SD
Decal												
✓ MS21042L08 		Purchased	No			150	Each	0.0000	4.0000		M112492	SD
Nut												
✓ MS21042L3 		Purchased	No			150	Each	0.0000	2.0000		M111668	SD
Nut												
✓ MS27039-08-11 		Purchased	No			150	Each	0.0000	2.0000		M111977	SD
Screw												
✓ MS27039-1-15 		Purchased	No			150	Each	0.0000	2.0000		M111914	SD
Screw												
✓ NAS1515H3 		Purchased	No			150	Each	0.0000	2.0000		M111268	SD
Washer												
✓ AN526C832R10 		Purchased	No			200	Each	0.0000	2.0000		M104603	SP
Screw												

9/10/14 SD

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Picklist Print

Page 5

Friday, June 26, 2009 9:18:36 AM

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Parent Item Name: Spacepod, RH, AS350/355









Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AN960JD516 		Purchased	No			210	Each	0.0000	2.0000			SP
Washer ✓ D2985RevA1 		Manufactured	No			210	Each	0.0000	1.0000			SP
Label ✓ D350-600-449RevC 		Manufactured	No			210	Each	0.0000	1.0000			SP
Switch Relocation ✓ D3547-1RevA 		Manufactured	No			210	Each	0.0000	1.0000			SP
Bracket ✓ D3550-1RevB 		Manufactured	No			210	Each	0.0000	1.0000			SP
Strut ✓ D3552-7RevD 		Manufactured	No			210	Each	0.0000	1.0000			SP
Door Prop ✓ D3554-7RevA 		Manufactured	No			210	Each	0.0000	1.0000			SP
Ball Stud ✓ K10021RevN/A 		Manufactured	No			210	Each	0.0000	1.0000			SP
Spacepod Hardware Kit (-241)												

M112794 SP

B48036 SP

47203 SP

B35455 SP

B48367 SP

B32644 SP

B37674 SP

B50276 SP

9/10/14

Friday, June 26, 2009 9:18:37 AM

Shop Packet Print

Page 5

Date: Friday, 22/05/2009 4:45:00 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD ASSEMBLY RH/ DSI 9335
Job Number :	48152		
Estimate Number :	12779		
P.O. Number :		Part Number :	D350600242
This Issue :	22/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	IIN REV.C PG11,18-21
First Issue :	//	Project Number :	N/A
Previous Run :	47002	Drawing Revision :	C
	Type :	Material :	
	SMALL /MED FAB	Due Date :	26/06/2009
Written By :		Qty:	1 Um: Each
Checked & Approved By :	JUL 09 05 25		
Comment :	Est Rev:A 07.03.07 new issue EC est rev B 07.04.16 reformat, D3188 rev.E EC Est Rev:C 08-09-30 add primer in step 44 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 ✓ DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

2.0 ✓ 48152A

SPACEPOD BODY RH



Comment: Sub-Component SPACEPOD BODY RH

1 x D3188-2M, Batch

3.0 ✓ 48152B

SPACEPOD DOOR RH



Comment: Sub-Component SPACEPOD DOOR RH

1 x D3186-4 Batch

4.0 ✓ D31872

Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

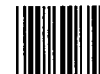
Pick:

Qty Part Number Description Batch

1 D3187-2 Floor

5.0 ✓ ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

✓ A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer - Countersunk

7.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes in D3188-2 using drill jig DT8971

2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188

3-Deburr

4-Install inserts in D3188-2 as per Dwg D3188.

8.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

✓ D29861

Rubber Spacer



Comment: Qty.: 1.0500 Each(s)/Unit Total : 1.0500 Each(s)

neoprene foam

batch: _____

10.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

11.0

✓ D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: _____

12.0

✓ D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

✓ AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH: _____

14.0

✓ D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: _____

15.0

✓ D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: _____

16.0

✓ MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: _____

17.0

✓ D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: _____

18.0

✓ D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: _____

19.0

✓ AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

✓ AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: _____

21.0

✓ MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: _____

22.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

****This step seperates hardware, previous steps is for body & floor****

23.0

✓ MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

24.0

✓ AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: _____

25.0

✓ NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: _____

26.0

✓ MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)
3/4 Seal
Cut 127.00" long batch: _____

28.0

D35672

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DECAL
batch: _____

29.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Door Latch
batch: _____

30.0

D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Clamp
batch: _____

31.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Latch Plate
batch: _____

32.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
batch: _____

33.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0



MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: _____

35.0



D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: _____

36.0



D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: _____

37.0



D2228

Bracket Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: _____

38.0



AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: _____

39.0



AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: _____

40.0



MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:01 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

✓ D35571

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: _____

42.0

✓ AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

43.0

✓ AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

44.0

✓ SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight.

A/R Hysol batch: _____ expire date: _____

A/R Milled fibres batch: _____

2- Prime (grey) as necessary per QSI005

Primer batch: _____

Hardner batch: _____

3-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: _____

45.0

✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:01 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

46.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

47.0

✓ HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: _____

48.0

✓ QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Wing Walk

49.0

✓ K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

50.0

✓ QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

51.0

✓ D350600449

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH RELOCATION KIT

47203

52.0

✓ D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label

batch: 78236

53.0

✓ D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: 35455

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:01 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

✓ D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: 48367

55.0

✓ D35527

Gas Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: 32644

56.0

✓ D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: 37674

57.0

✓ AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: 112794

58.0

✓ D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: 48238

59.0

✓ QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

60.0

✓ PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location: _____

PPP Rev: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:01 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY RH/ DSI 9335

Job Number: 48152

Part Number: D350600242

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

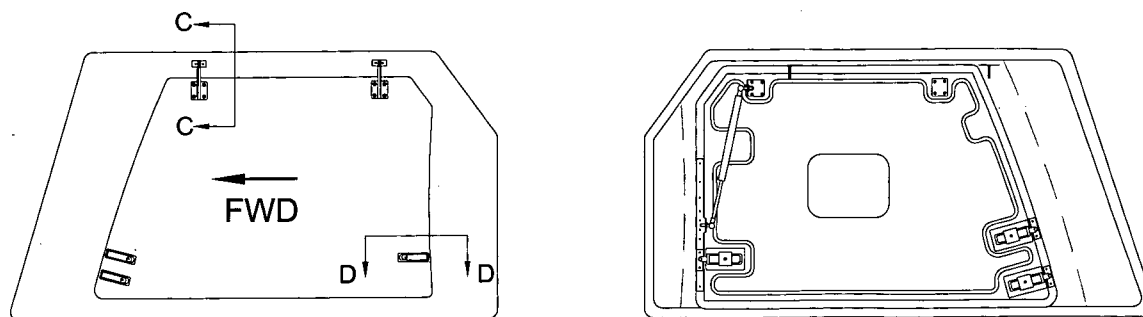


FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)

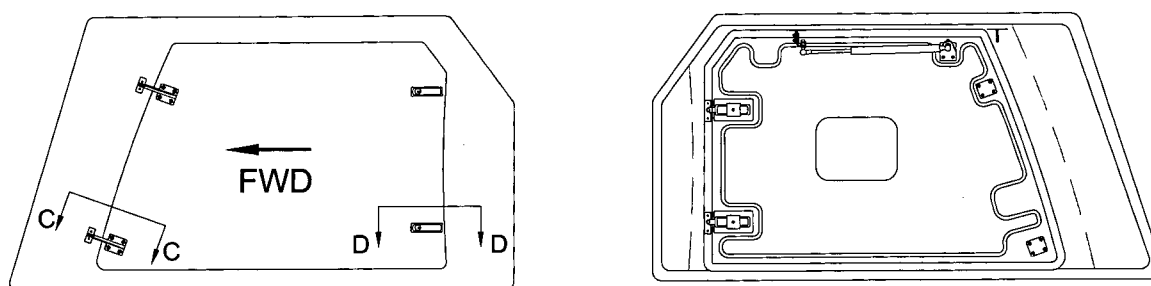
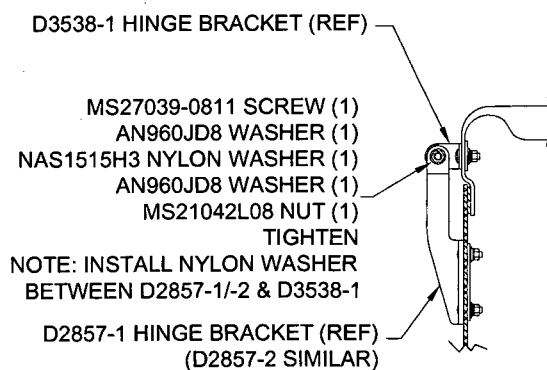
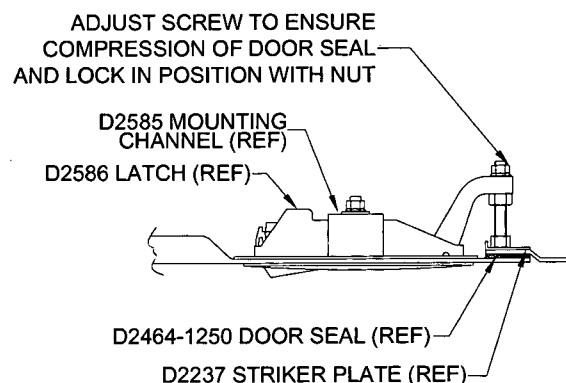


FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



SECTION 'C-C' HINGE
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)



SECTION 'D-D' LATCH

- 3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:
- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
 - If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
 - Re-install the belly panel per the Aircraft Maintenance Manual.

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- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).

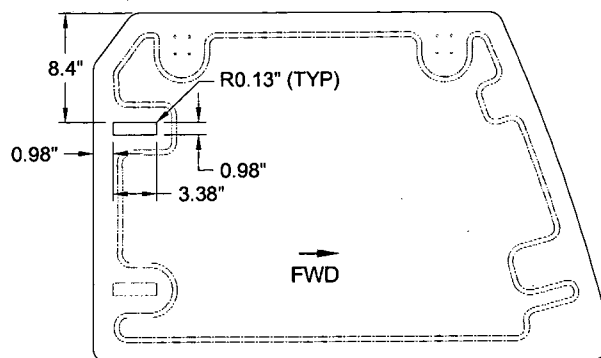


FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -041/-043/-141/-143 KITS)

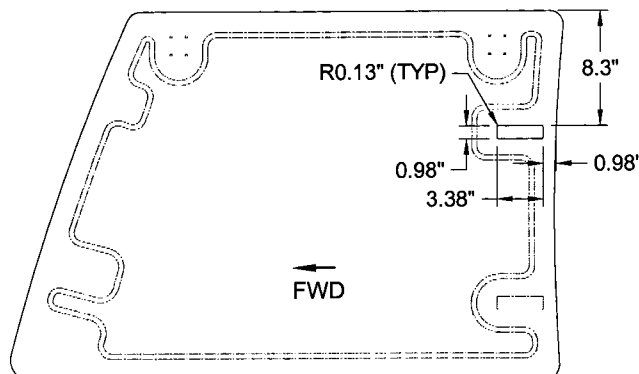


FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -042/-142 KITS)

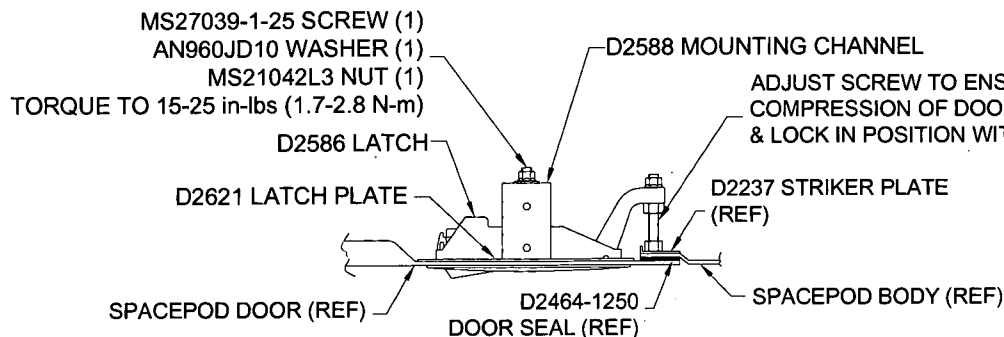


FIGURE 14(c). LATCH INSTALLATION
(SHOWN WITH DOOR INSTALLED ON POD)

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- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the $\varnothing 0.172$ " mounting holes on each bracket to the *Spacepod™* door. Install the hinge brackets as shown in Section J-J.

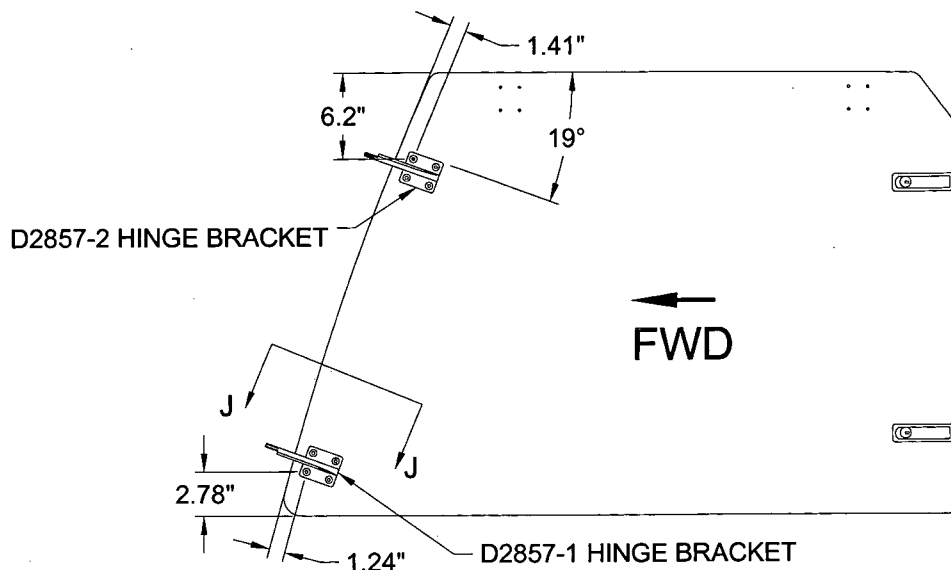


FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR

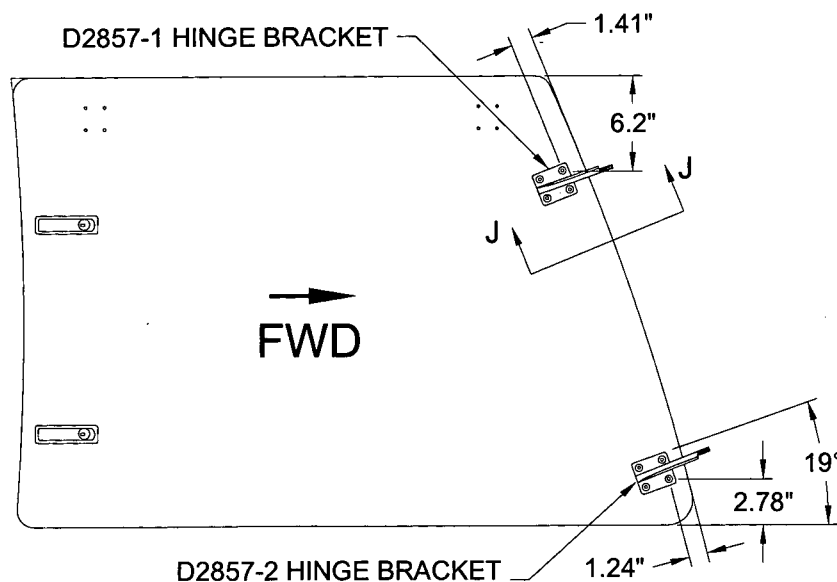
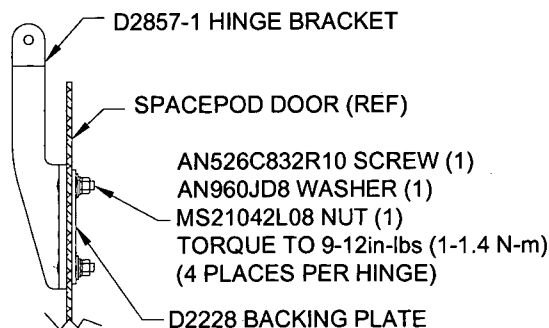


FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR

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SECTION 'J-J' HINGE BRACKET INSTALLATION
 (D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.

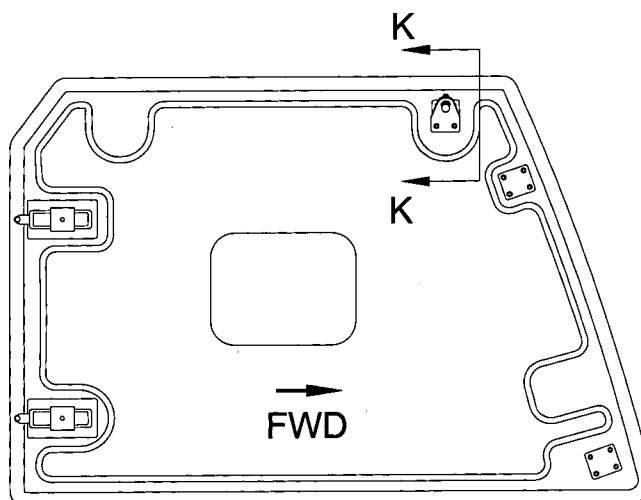
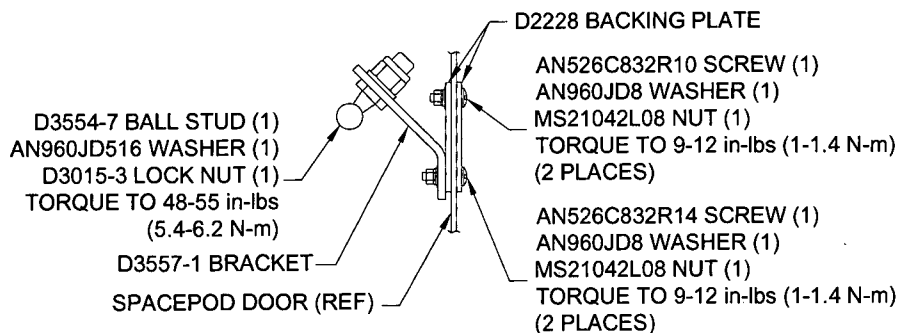


FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR
 (INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



SECTION 'K-K'

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Revision: **C**
 Date: 07.02.20

- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
 - Remove the door and drill Ø0.375" holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the **Spacepod™** door and hinges and transfer drill the Ø0.172" D3538-1 hinge bracket mounting holes to the pod.
 - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).

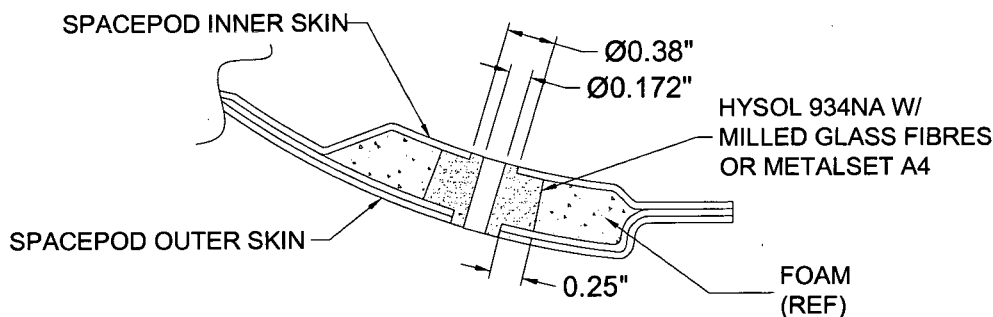


FIGURE 17(a). COMPOSITE MODIFICATION

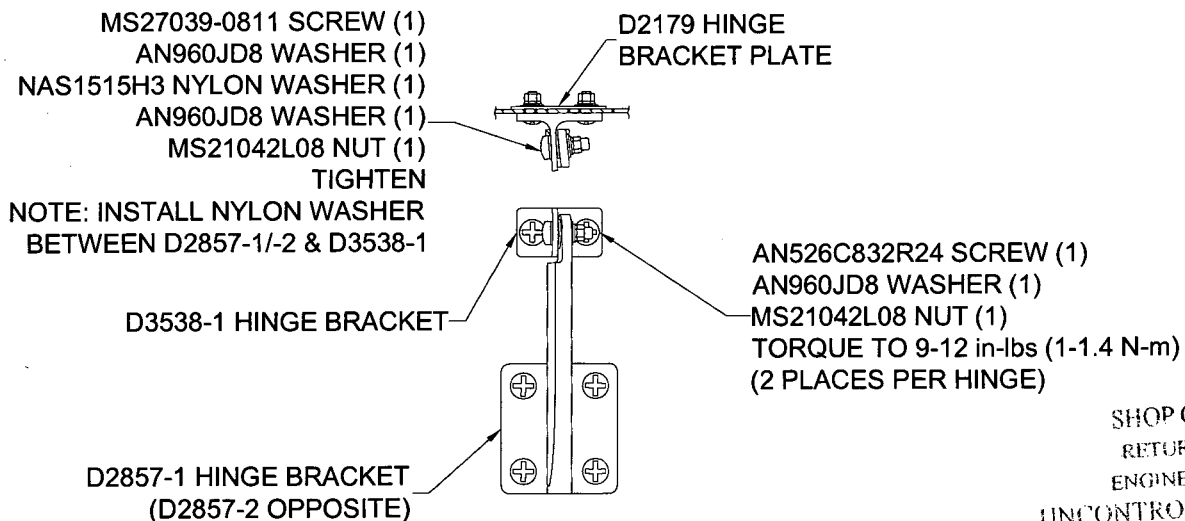


FIGURE 17(b). HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 OPPOSITE)

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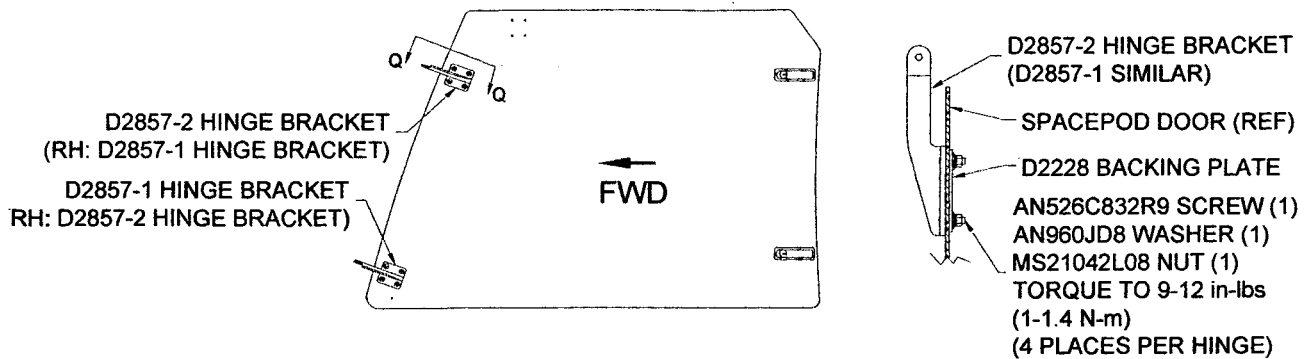


FIGURE 21. HINGE BRACKET INSTALLATION
(-041/-141 KITS SHOWN; -043/-143 SIMILAR; -042/-142 OPPOSITE)

SECTION 'Q-Q'

- 3.5.5 Install the D3538-1 hinge brackets on the pod as shown in Figure 22:
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown. Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the *Spacepod™* body.
 - Remove the door and drill $\varnothing 0.375"$ holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 22(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the *Spacepod™* door and hinges and transfer drill the $\varnothing 0.172"$ D3538-1 hinge bracket mounting holes to the pod.
 - Install the D3538-1 hinge brackets and *Spacepod™* door as shown in Figure 22(b).

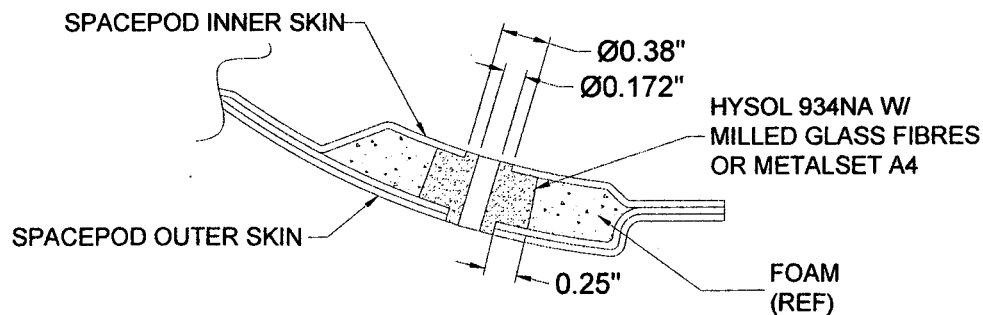


FIGURE 22(a). COMPOSITE MODIFICATION

48152

EA 956 AA13
LNM/PWT

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 14, 2009 1:05 AM
To: 'Chris Provencal'
Cc: 'Dan Stow'
Subject: RE: Pod deviation # 1278

Chris,

I agree with this substitution for exactly the reasons you have outlined below.
The only purpose of the resin in this case is to provide something hard to clamp up on.
I would go ahead and finish the pod now.

Regards,
David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, October 13, 2009 2:31 PM
To: 'David Shepherd'
Cc: 'Dan Stow'
Subject: Pod deviation # 1278

David,

RE: D350-600 spacepod:

They need to drill the door to attach the hinges, as shown in Figure 22a of IIN-D350-600 (attached). They are out of Hysol EA934NA; ETA is end of October for more. Russ does have some EA956, which is called up in QSI 037 for laminating/potting. In this application, there is no insert being potted, the resin is simply being drilled.

Comparing the resins EA956 / EA934:

Tensile strength: 5,800 psi / 5,800 psi
Compressive: 12,000 psi / 9,500 psi
Hardness (Shore D): 85 / 85
Bond strength: 2,300 psi / 3,100 psi (how well it bonds to aluminum test sample).

The EA956 appears to be equal to EA934, except it is weaker in bond strength. So it's obviously not as good a substitute for holding inserts, however in this case it simply needs to withstand the bearing of the bolt through the hole. Based on the compressive/hardness values it seems to be up to the task.

The pod is for stock, so it can wait until November unless there's an order.

Sincerely,
Christopher Provencal
DART Aerospace Ltd.

cprovencal@dartaero.com
Tel: (613) 632 5200
Fax: (613) 632 9311

No virus found in this incoming message.
Checked by AVG - www.avg.com
Version: 8.5.421 / Virus Database: 270.14.13/2432 - Release Date: 10/13/09 06:35:00

2009-10-14